

Work Order ID 77177

77177

Page 1

November-28-11 9:02:21 AM

Item ID: D412-750-141

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Tail Light Fairing, LH

Start Date: 28/11/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 11/11/28 Tooling:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

2 SP

N/A

Rev A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D412-750-141 CHG001

Sulizloz

J. Chr MLJ 11-12-7
(5)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

SP 11-12-07

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

***** Ensure part is a L/H as per dwg *****

Sulizloz

45
47

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77177

77177

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November-28-11 9:02:21 AM

Item ID: D412-750-141

Accept

N900040100

Setup Start *NS1*

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Stop *NS2*

Item Name: Tail Light Fairing, LH

Start Date: 28/11/2011 Start Qty: 5.00

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Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 5.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-750-141 Location: 123 PPP Rev: A								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

11-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-28-11 9:02:25 AM

Page 1

Work Order ID: 77177

77177

Parent Item: D412-750-141

D412-750-141

Parent Item Name: Tail Light Fairing, LH

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP revA 06.09.22 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN3-3A		Purchased	No			120	Each	277.0000	10	50			
AN3-3A													
Bolt													

Location

Loc Qty

Loc Code

ST350

277

118628

107

119328

170

AN960JD10	NAS1149D0363J	Purchased	No			120	Each	0.0000	10	50			
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AN960JD10

Washer

D3484-041

Manufactured No

120 Each 0.0000

D3484-041

Tail Light Fairing Assembly, LH

**

**

**

SP

50x

M119537 SP

B75827

SP11-12-07

S

S

S

LH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

- 3.8 Fasten the D3484-041/-042 Tail Light Fairing complete with A2064-1683 Tail Light Assembly to the tailboom using the provided (10) AN3-3A bolts into the tailboom's existing holes. Torque bolts 15-25 lb-in (1.7-2.8 N-m). Refer to Figure 1, Detail A.

4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the installation of the D412-750-141/-142 Tail Light Fairing Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-750-141	0.13 lb	6.0 in	0.78 lb-in	296.1 in	38.49 lb-in
<i>Tail Light Fairing Kit, LH</i>	0.06 kg	0.2 m	0.01 kg-m	7.5 m	0.45 kg-m
D412-750-142	0.13 lb	6.0 in	0.78 lb-in	296.1 in	38.49 lb-in
<i>Tail Light Fairing Kit, RH</i>	0.06 kg	0.2 m	0.01 kg-m	7.5 m	0.45 kg-m

5.0 PARTS LIST

Qty - 141	Qty - 142	Part Number	Description
X		D412-750-141	TAIL LIGHT FAIRING KIT, LH
	X	D412-750-142	TAIL LIGHT FAIRING KIT, RH
1		D3484-041	TAIL LIGHT FAIRING ASS'Y, LH
	1	D3484-042	TAIL LIGHT FAIRING ASS'Y, RH
10	10	AN3-3A	BOLT
10	10	AN960JD10	WASHER

8

7

6

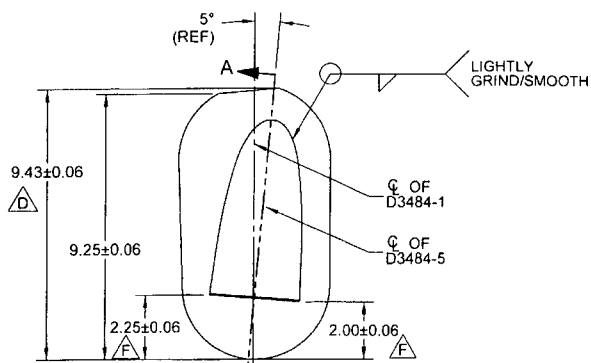
5

4

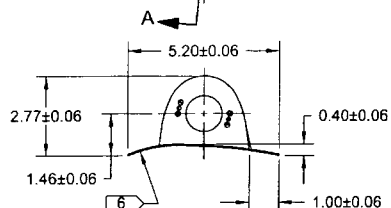
3

2

1



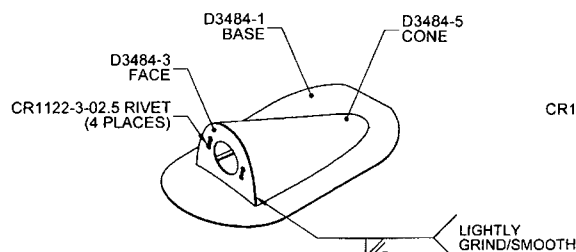
QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (LH)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (RH)
1		D3484-1	BASE (LH)
	1	D3484-2	BASE (RH)
1		D3484-3	FACE (LH)
	1	D3484-4	FACE (RH)
1		D3484-5	CONE (LH)
	1	D3484-6	CONE (RH)
4	4	CR1122-3-02.5	RIVET
2	2	MS21069-04	ANCHOR NUT



INSTALL MS21069-04
ANCHOR NUT
(2 PLACES)

SECTION A-A

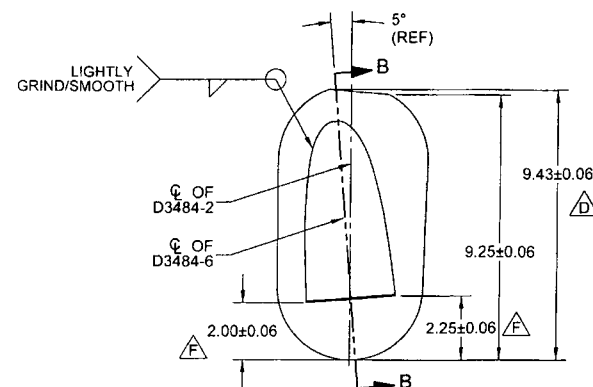
D3484-041 TAIL LIGHT FAIRING



D3484-041 ISOMETRIC VIEW

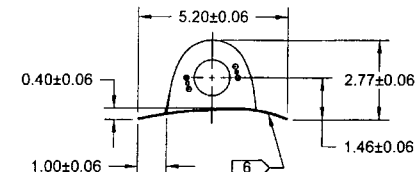
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) WELDING: PER DART QSI 004
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:
"TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141/-142 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA06-13"
- 7) WEIGHT: 0.30 lbs

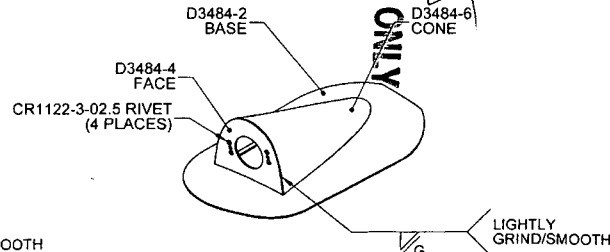


INSTALL MS21069-04
ANCHOR NUT
(2 PLACES)

SECTION B-B



D3484-042 TAIL LIGHT FAIRING



D3484-042 ISOMETRIC VIEW

RELEASED
09/03/31

F	UPDATE MATERIAL SPEC. ADD 8051-0, ZN A7-2, A7-3, B3-4, UPDATE DIMENSIONS ZN C1-1, C2-1, C7-1, C8-1, UPDATE WELDING NOTE ZN A3-1, A6-1		09.03.31
E	REDRAWN/REFORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY. CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS). DIM 1.560 WAS 1.563 (SHEET 3, ZONE B4); CR1122-3-02.5 RIVET WAS MS2042BAD3-3 RIVET	MB	08.01.03
D	CORRECT D3484-1F	MB	06.06.22
C	RE-DESIGN D3484-3F/-5F	MB	06.04.20
B	RE-DESIGN	MB	06.02.21
A	NEW ISSUE	MB	05.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.31		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3484** REV. F
SHEET 1 OF 4
TITLE **TAIL LIGHT FAIRING** SCALE 1:4

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